

Work Order ID 69339

Monday, May 09, 2011 11:32:20 AM

Page 1

Item ID: D350-588-041

Accept

Revision ID:

Item Name: Aft Door Assembly

Start Date: 5/9/2011 Start Qty: 1.00

Required Date: 5/13/2011 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: PL Date: 11-05-9

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2445/D350-588

Rev D/D

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-588-041 CHG003

S. W. 11-05-9

Dear BG 11-7-20 Ato →

110

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 14039
Description: D2445 Baggage Door
Supplier: Delastek
Ship to Delastek (1) D0588-041 label
Certification of Conformity and process sheet from Delastek is required.

PL 11-05-9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

see attached E-mail

Part No: D320-588-41 PAR #: _____ Fault Category: Production Engineering ~~Coordination~~ NCR: Yes ~~No~~ DQA: _____ Date: _____

Resolution: Fix w/o + Dam Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>69339</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>11/7/19</u> <u># 100</u>	<u># 100</u>	<u>Exams that on w/o</u> <u>Pick list is missing</u> <u>AN960JDB for the kit</u> <u>Re. Bom + w/o not created</u>	<u>GP</u> <u>11.07.20</u> <u>DS1642</u>	<u>→ ADD missing</u> <u>AN960JDB qty x16</u> <u>M# 117316</u> <u>Per Kit</u>	<u>[Signature]</u> <u>11/7/19</u>	<u>S</u> <u>11/7/19</u>	<u>P</u> <u>11.07.20</u> <u>DS1642</u>	<u>S</u> <u>11/7/19</u>
		<u>Correctly Lack of Attention</u>	<u>GP</u> <u>11.07.20</u>	<u>Update Bom + w/o. ADD</u> <u>A copy of total correctly update</u> <u>Bom for Ref.</u>	<u>[Signature]</u> <u>11.08.03</u>	<u>11.08.03</u>	<u>GP</u> <u>11.07.20</u>	<u>S</u> <u>11/7/19</u>
				<u>* AN960JDB is replaced</u> <u>by NAS1149DN832J</u> <u>[Signature]</u>				

NOTE: Date & initial all entries

Work Order ID 69339

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Revision ID:

Item Name: Aft Door Assembly

Start Date: 5/9/2011 Start Qty: 1.00

Required Date: 5/13/2011 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

Ensure Certificate of Conformity & Process Sheet are attached

1647/10 (C)

130

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

Inspect as per Dwg D2445.
Audit process sheet.

S 11/07/16

(40)

140

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Assemble all of the above parts as per Dwg D350-588

87 11-07-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Revision ID:

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Required Date: 5/13/2011 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

155

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

160

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 69339

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Item ID: D350-588-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Door Assembly

Start Date: 5/9/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/13/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 	Identify as per dwg & Stock Location: <u>42</u>	0.00							
Packaging	Memo	0.00							
Packaging									
180 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/7/20

11/7/20

ME
11-07-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Monday, May 09, 2011 11:32:27 AM

Page 1

[illegible]**Required Date: 5/13/2011**

Required Qty: 1.00

IPP Rev:Q as
IPP Rev:R add pick kit DD

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST327	603	
117010	7	
117619	196	
<u>117628</u>	400	
	140	Each 0.0000
117291		
	140	Each 31.0000

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST198	31	
64308	31	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 69339

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 5/9/2011

Required Date: 5/13/2011

Start Qty: 1.00

Required Qty: 1.00

D2144

Manufactured No

140 Each

20.0000 1 1



Hinge Bracket



ET 11-07-18

Location

Loc Qty

Loc Code

ST198

20

64778

20

D2463

Manufactured No

140 f

555.0600 7.25



Seal



x1
7.25

RT 11-07-18

Location

Loc Qty

Loc Code

ST404

555.06

64944

62.66

66954

492.4

x7.25

(D2463-0870) cut (1) at 87.00"
**** per kit****

D2585

Manufactured No

140 Each

41.0000 2 2



Mounting Channel



ET 11-07-18

Location

Loc Qty

Loc Code

ST017

41

66142

41

D2586

Manufactured No

140 Each

107.0000 2 2



Door Latch



RT 11-07-18

Location

Loc Qty

Loc Code

ST204

107

64656

7

64774

100

x2

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Page 3

Monday, May 09, 2011 11:32:28 AM

Work Order ID: 69339

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 5/9/2011

Required Date: 5/13/2011

Start Qty: 1.00

Required Qty: 1.00

D2621

Manufactured No

140

Each

42.0000

2

2



Latch Plate, 350 Spacepod



8T 11-07-18

Location

Loc Qty

Loc Code

ST019

42

56526

42

X2

D2857-1

Manufactured No

140

Each

1.0000

1

1



Hinge Bracket



8T 11-07-18

66983

Location

Loc Qty

Loc Code

ST024

1

64435

1

D2857-2

Manufactured No

140

Each

21.0000

1

1



Hinge Bracket



8T 11-07-18

Location

Loc Qty

Loc Code

ST024

21

64463

11

65091

10

XC

MS21042L08

Purchased No

140

Each

303.0000

8

8



Nut



8T 11-07-18

117739

Location

Loc Qty

Loc Code

ST300

303

117087

6

117441

97

117601

200

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Monday, May 09, 2011 11:32:28 AM

Work Order ID: 69339

Parent Item: D350-588-041


Parent Item Name: Aft Door Assembly

Start Date: 5/9/2011


Required Date: 5/13/2011

Start Qty: 1.00


Required Qty: 1.00

MS21042L3 Purchased No 140 Each 2,400.000 2 2

 Nut

Location	Loc Qty	Loc Code
ST300	2400	
116391	11	
116540	423	
116549	766	
117441	800	
117601	400	

MS27039-1-15 Purchased No 140 Each 100.0000 2 2

 Screw

Location	Loc Qty	Loc Code
ST292	100	
116916	100	

AN526C1032R7 Purchased No 155 Each 76.0000 2 2

 Screw

Location	Loc Qty	Loc Code
MEZZ	2	
113064	1	
113749	1	
ST328	74	
116304	74	

AN526C832R8 Purchased No 155 Each 33.0000 -8 8

 Screw

Location	Loc Qty	Loc Code
ST327	33	
116471	33	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Monday, May 09, 2011 11:32:28 AM

Work Order ID: 69339

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 5/9/2011

Required Date: 5/13/2011

Start Qty: 1.00

Required Qty: 1.00

AN960JD10 NAS1149D0363J Purchased No

155 Each

0.0000

2 2



Washer

D2150

Manufactured No

155 Each

9.0000

2 2



Packer Doubler, Hinge

Location

Loc Qty

Loc Code

ST006

9

64764

9

Manufactured No

155 Each

17.0000

2 2

D2151



Packer Doubler, Hinge

Location

Loc Qty

Loc Code

ST006

17

64776

17

Manufactured No

155 Each

26.0000

1 1

D2153



Door Prop

Location

Loc Qty

Loc Code

ST272

26

64943

26

Manufactured No

155 Each

34.0000

1 1

D2154



Stud Bracket

Location

Loc Qty

Loc Code

ST006

34

64312

34

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

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Monday, May 09, 2011 11:32:29 AM

Work Order ID: 69339

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 5/9/2011

Required Date: 5/13/2011

Start Qty: 1.00

Required Qty: 1.00

D2237

Manufactured No

155

Each

66.0000

2

2



Striker Plate

Location

Loc Qty

Loc Code

ST009

66

64762

2

66139

64

D2461

Manufactured No

155

f

196.5000

7.25

7.25



Neoprene "D" Seal

Location

Loc Qty

Loc Code

ST402

196.5

39782

6.5

55054

4

63880

186

(D2461-0870) cut (1) at 87.00"

**** per kit****

D2589

Manufactured No

155

Each

110.0000

1

1



Keys, Key Chain, 350 Hinge

Location

Loc Qty

Loc Code

ST018

110

58194

110

D2690-17

Manufactured No

155

Each

22.0000

1

1



Cable

Location

Loc Qty

Loc Code

ST020

22

64786

1

66510

21

Monday, May 09, 2011 11:32:29 AM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 5/9/2011

Required Date: 5/13/2011

Start Qty: 1.00

Required Qty: 1.00

D2858-1 Manufactured No

155 Each

11.0000

1

1



Hinge Bracket

Location

Loc Qty

Loc Code

ST024

11

64785

11

Manufactured No

155 Each

11.0000

1

1

D2858-2



Hinge Bracket

Location

Loc Qty

Loc Code

ST024

11

64787

11

Purchased No

155 sf

2,673.970

1

1

FG-778150-550-ROL



7781 9oz Glass 50"x125yd

Location

Loc Qty

Loc Code

CA

1649.97

117602

1649.97

ST404

1024

104845

3

108932

18

111166

392

113905

611

CUT ONE SQUARE FEET PER KIT

MS20426AD3-4

Purchased No

155 Each

5,258.000

12

12



RIVET

Location

Loc Qty

Loc Code

ST316

5258

104374

1258

110398

4000

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Required Date: 5/13/2011

Start Qty: 1.00

Required Qty: 1.00

MS20470AD4-5

Purchased

No

155

Each

1,533.000

18

18



Rivet, Universal Head

Location

Loc Qty

Loc Code

ST319

1533

116410

14

116893

1519

MS21042L08

Purchased

No

155

Each

303.0000

10

10



Nut

Location

Loc Qty

Loc Code

ST300

303

117087

6

117441

97

117601

200

MS21042L3

Purchased

No

155

Each

2,400.000

4

4



Nut

Location

Loc Qty

Loc Code

ST300

2400

116391

11

116540

423

116549

766

117441

800

117601

400

MS27039-08-11

Purchased

No

155

Each

183.0000

2

2



Screw

Location

Loc Qty

Loc Code

ST290

183

116289

33

117441

150

Monday, May 09, 2011 11:32:30 AM

Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

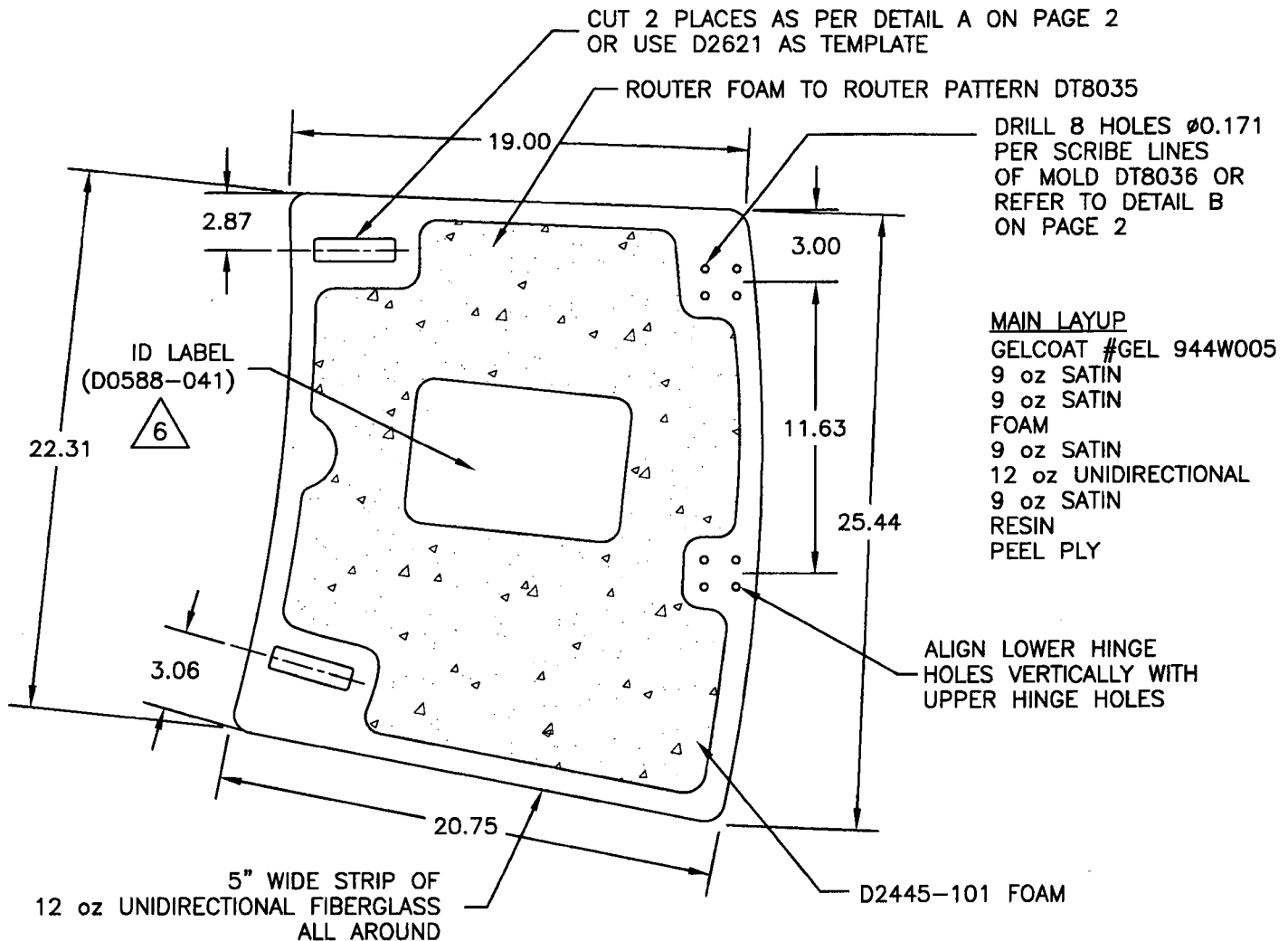
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NOTE: Date & initial all entries

DART

DESIGN JB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2445	REV. D SHEET 1 OF 2
DATE 06.06.09		TITLE AFT BAGGAGE DOOR	SCALE 1:7
A	97.07.15	NEW ISSUE	
B	02.01.24	ADD D2621; D2445-101	
C	04.02.09	REMOVE D2621; UPDATE NOTES	
D	06.06.09	ADD DIMENSIONS TO PERIMETER	

RELEASED06.11.13 *[Signature]***NOTES:**

- 1) USE MOLD DT8036 FOR DOOR LAYUP. TRIM AND DRILL PER DT8619
- 2) RESIN: DERAKANE 411/510A40/470-36
- 3) FOAM: 3/8" A500 CORE CELL OR DMVYCELL OR AIREX OR KLEGECELL R-75
- 4) FIBRE: 9.7 oz 7781 WEAVE "S" GLASS ("9 oz SATIN")
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
- 5) BOND FOAM CORE TO LAMINATE USING POLYBOND B46F
- 6) LAMINATE LABEL USING SURFACE VEIL AND EPOXY RESIN.
- 7) LAMINATE PER DART QSI 006 4.0
- 8) LAMINATION SCHEDULE PER THIS DRAWING
- 9) FINISH INSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 10) ALL DIMENSIONS ARE IN INCHES
- 11) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

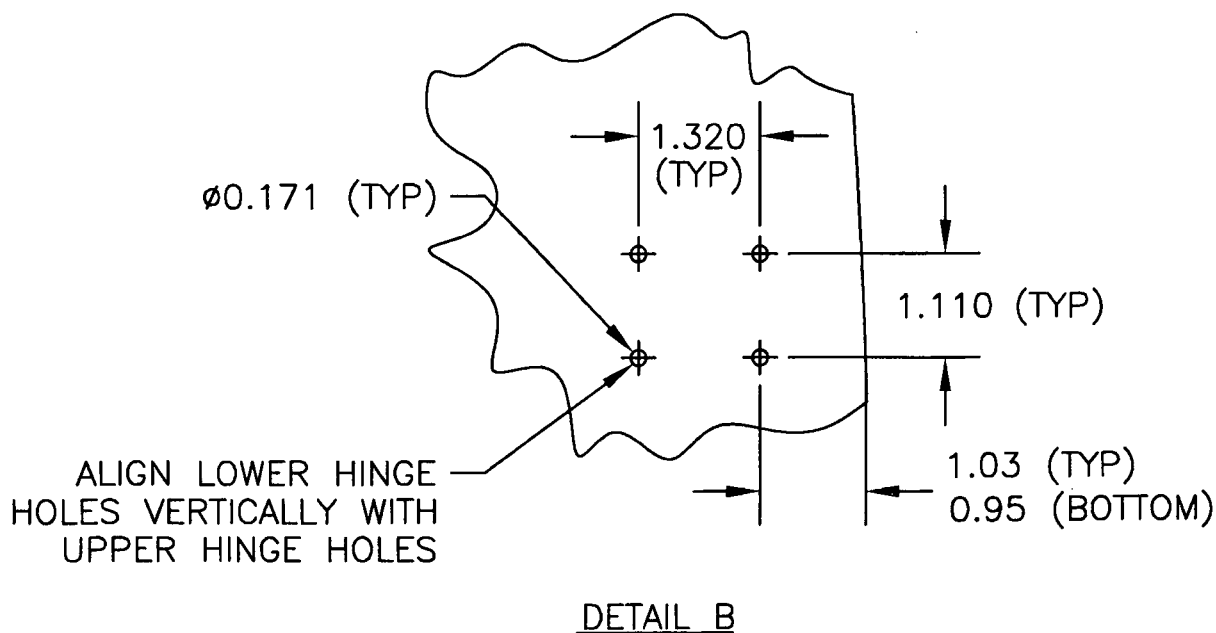
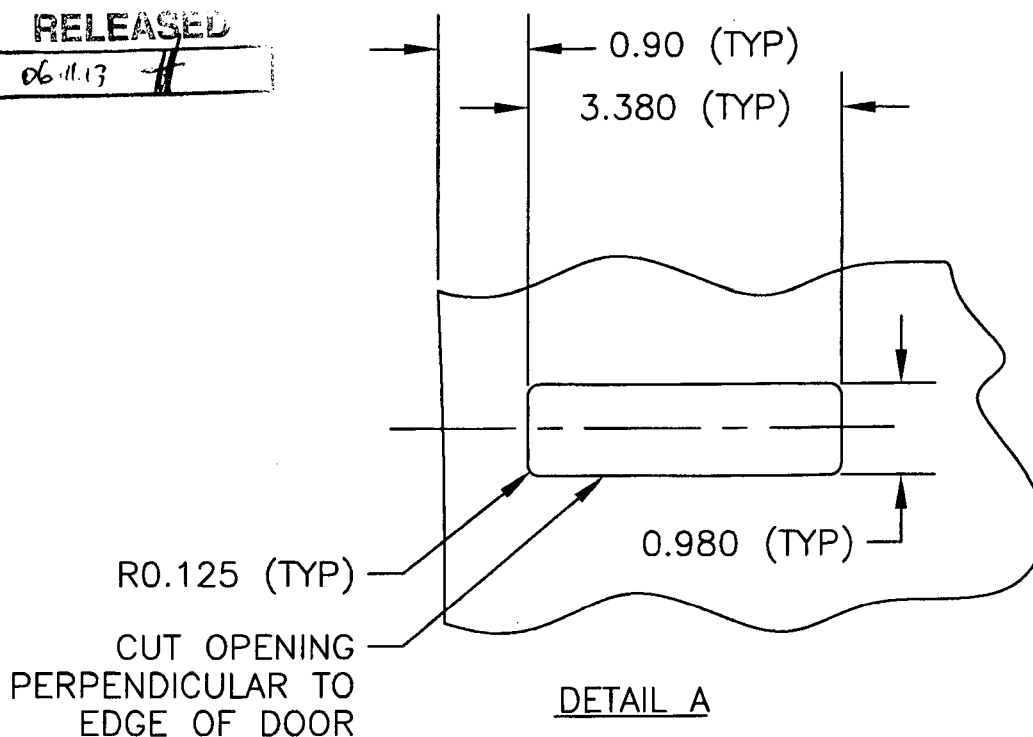
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN JB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2445	REV. D SHEET 2 OF 2
DATE 06.06.09		TITLE AFT BAGGAGE DOOR	SCALE 1:2

RELEASED
06.11.13 *[Signature]*



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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Delastek inc.
2699 5e avenue
Local 14, Porte -A-
Grand-Mère, Québec G9T 5K7
Can ** Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	39365
Customer #	DART US

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Ship to:

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone: 613-632-5200

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
FEDEX P1 Collect		Point de départ		Net 30 days USA		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
14/07/2011	09/05/2011	17521	Brigitte Golden		14039		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0013	Line 2 D350-588-041 Aft Baggage Door (D2445) B69342 U de M : Each Drawing N° : D2445 Rév.: D <u>No. série</u> B69339 <u>No. lot</u> 33207 Sub 1/2			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

[Signature]

Quality department



AQ-357

Date: Lundi, 2011-05-09 17:47:20
Utilisateur: Pascal Carignan

Feuille de Procédé

Cliant : DART US DART AEROSPACE LTD
Numéro Job : 33207
Numéro Soumission : 3953
Numéro B.A. : Kit 854
Cette fois : 2011-05-09 No. B.V. :
Prsht Rev. : NC
Prem. fois : - - Type :
Job précédente : 33206

Nom Dessin : N° D2445, AFT BAGGAGE DOOR
Numéro Article : DKC134-0013
Numéro Dessin : D2445
Projet Numéro : DK-134
Révision dessin : D
Matériel : Composite
Date Dûe : 2011-05-16 Qté: 1 UdM: UNITÉ

Écrit par :
Vérifié & Approuvé par :
Commentaires : N° de pièce Client: D2445

869339

Process Sheet Rév.: 01 changer le sikkens AAC1390 pour le P15 3
(AAC1492), enlever le AAC1617, changer le frekote 44-NC pour le
Wolo

Produit additionnel

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
1.0	AAC1616	N° 83634, Frekote Loctite Wolo

Commentair Qty.: 0.200 UNITE(s)/Unit Total : 0.200 UNITE(s)
N° 83634, Frekote Loctite Wolo # de Lot: _____

2.0	PREP-GENERAL	Préparation du matériel
-----	--------------	-------------------------



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation du moule N° DT-8036 selon IG 0009.

Date: _____ Sceau: _____

3.0	AMB0350	Gel Coat Blanc N° Gel 944W005
-----	---------	-------------------------------

Commentair Qty.: 0.200 KILOGRAMME(s)/Unit Total : 0.200 KILOGRAMME(s)
Gel Coat Blanc N° Gel 944W005 N° de Lot: 1-31135-1

4.0	AMB0286	Catalyst N° DDM-9
-----	---------	-------------------

Commentair Qty.: 0.0320 GALLON(s)/Unit Total : 0.0320 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-27829-1

5.0	PREP-GENERAL	Préparation du matériel
-----	--------------	-------------------------



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% catalyst par quantité de résine.

Date: 16/06/11 Sceau: _____



Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 33207

Nom Dessin: N° D2445, AFT BAGGAGE DOOR
Numéro Article: DKC134-0013

Numéro Job:



Séq.: Machine ou Opération: Description :

6.0 GEL COAT Application du Gel Coat



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'application du Gelcoat selon IG 0019

Date: 16/06/11 Sceau:



7.0 AC0883 Tissu à délaminer Release ply B

Commentair Qty.: 1.52 VERGE(s)/Unit Total : 1.52 VERGE(s)

8.0 AC0884 Wrightlon 5200 Bleu P3

Commentair Qty.: 3.33 VERGE(s)/Unit Total : 3.33 VERGE(s)

9.0 AC0885 Feutre de drainage N° Airweave N 10

Commentair Qty.: 2.78 VERGE(s)/Unit Total : 2.78 VERGE(s)

10.0 AC0943 Stretchlon 200 poche à vide Vert

Commentair Qty.: 2.00 PIED(s)/Unit Total : 2.00 PIED(s)

11.0 AMB0214 9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

Commentair Qty.: 2.0 VERGE(s)/Unit Total : 2.0 VERGE(s)

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

N° de Lot: 1-31000-2

12.0 AMB0349 Fiberglass 12 oz Unidirectional

Commentair Qty.: 0.33 VERGE(s)/Unit Total : 0.33 VERGE(s)

Fiberglass 12 oz Unidirectional

N° de Lot: 1-22549-1

13.0 AC0886 Ruban à gommer jaune #: TIAT-200Y

Commentair Qty.: 1.2500 ROULEAU(s)/Unit Total : 1.2500 ROULEAU(s)

14.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Tailler le matériel, selon les différents patrons de découpe comme suit:

4 plis de tissus de 9.7 oz.

1 pli de 12 oz. pour tout le contour de la pièce par 5" de large.

3 fois le sac à vide Stretchlon 200.

3 fois le film perforé P-3

3 fois le feutre de drainage

2 fois le tissu à délaminer (non nécessaire lors du bagging du core).

Appliquer le ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.

Afin d'accélérer le processus de taillage, tailler les plis de 9.7 oz. tous en même temps, en les superposant les uns sur les autres.

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 33207

Nom Dessin: N° D2445, AFT BAGGAGE DOOR
Numéro Article: DKC134-0013

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

20.0	AMB0286	Catalyst N° DDM-9
------	---------	-------------------

Commentair Qty.: 0.0042 GALLON(s)/Unit Total : 0.0042 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-27829-1

21.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.
------	---------	---

Commentair Qty.: 0.120 KILOGRAMME(s)/Unit Total : 0.120 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-31015-1

22.0	PREP-GENERAL	Préparation du matériel
------	--------------	-------------------------



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation de la résine selon les quantités requise, mix ratio 1.5% de catalyst N° DDM-9 par quantité de résine N° 411-350, Imbiber toutes les surfaces du Foam Core selon IG0105.

Date: 17/06/11 Sceau:



23.0	AAC1611	Polybond B46F
------	---------	---------------

Commentair Qty.: 0.045 KIT(s)/Unit Total : 0.045 KIT(s)
Polybond B46F N° de Lot: 1-27795-1

24.0	DKC134-0029	Foam Core N° D2445-101 (Pour AFT Baggage Door)
------	-------------	--

Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)
Foam Core N° D2445-101 (Pour AFT Baggage Door) N° de Job: 33662

25.0	ASSEMBLAGE	Assemblage mécanique
------	------------	----------------------



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Assembler le DKC134-0029 selon IG 0033

Date: 17/06/11 Sceau:



26.0	BAGGING	Faire le bagging sur la pièce
------	---------	-------------------------------



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la poche à vide selon IG 0012

Retirer le bagging avant la fin de la polymérisation (entre 1h et 1h30) afin d'enlever le surplus de Polybond.

Heure début Curing: 12:40

Heure Fin Curing: 2:10

Date: 17/06/11 sceau:



Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: N° D2445, AFT BAGGAGE DOOR

Numéro Job: 33207

Numéro Article: DKC134-0013

Numéro Job:



Séq.: Machine ou Opération: Description :

27.0 AMB0286 Catalyst N° DDM-9

Commentair Qty.: 0.1360 GALLON(s)/Unit Total: 0.1360 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-27829-1

28.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.360 KILOGRAMME(s)/Unit Total: 0.360 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-37288-1

29.0 PREP GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% de catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 23/06/11 Sceau:

Alb

30.0 LAMINAGE

Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire le laminage d'un pli de 9.7 oz.

Faire le laminage du plis de tissu 12 oz. tout le tour de la porte en prenant bien soin que les deux bandes allant dans le coin droit en bas se superposent

Faire le laminage du dernier pli de 9.7 oz.

Date: 23/06/11 Sceau:

Alb

31.0 BAGGING

Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la poche à vide selon IG 0012

Laisser sécher pendant 4 heures minimum.

Heure Curing Début: 1:45 Heure Curing Fin: 4:00 le 27/06/11

Date: 23/06/11 Sceau:

Alb

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: N° D2445, AFT BAGGAGE DOOR

Numéro Job: 33207

Numéro Article: DKC134-0013

Numéro Job:



Séq.: Machine ou Opération: Description :

32.0 DÉMOULAGE Démoulage de la pièce



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Démouler la pièce en faisant bien attention aux coins & Edges.

Date: 27/06/11 Sceau:



33.0

TRIMAGE

Trimage



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

À l'aide du gabarit N°DT 8619 trimer la pièce en utilisant un router muni d'un couteau 1/4" et d'un " Bushing " 1/16" de mur.

Percer les " Latch " et les trous de penture selon le dessin N° D2445.

Date: 29/06/11 Sceau:



34.0

AAC1605

Label N° D0588-041

Commentair Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)
Label N° D0588-041 N° de Lot: 1-31017-1

35.0

AAC1609

Surface Veil

Commentair Qty.: 0.07 VERGE(s)/Unit Total: 0.07 VERGE(s)
Surface Veil N° de Lot: N/A

36.0

AAC1220

Résine Mia-Poxy 100

Commentair Qty.: 0.007 GALLON(s)/Unit Total: 0.007 GALLON(s)
Résine Mia-Poxy 100 N° de Lot: 1-25679-1

37.0

AAC1221

Durcisseur 95 Pour Résine Mia-Poxy

Commentair Qty.: 0.007 QUART(s)/Unit Total: 0.007 QUART(s)
Durcisseur 95 Pour Résine Mia-Poxy N° de Lot: 1-26296-2

38.0

ASSEMBLAGE

Assemblage mécanique



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Coller le label N° D0588-041 selon IG 0111.

Date: 30/06/11 Sceau:



Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: N° D2445, AFT BAGGAGE DOOR

Numéro Job: 33207

Numéro Article: DKC134-0013

Numéro Job:



Séq.: Machine ou Opération: Description :

39.0 AAC1492 N° P-15-3, Adtech Micro Ultra Filler

Commentair Qty.: 0.014 GALLON(s)/Unit Total : 0.014 GALLON(s)

N° P-15-3, Adtech Micro Ultra Filler

de Lot: 1-31178-3

40.0 FINITION Finition Générale



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire les réparations de finition s'il y a lieu à l'aide du "Filler" P15-3.

Date: 5/07/11 Sceau:



41.0 AAC1021 Dupont Primer N° 7704S

Commentair Qty.: 0.0280 UNITE(s)/Unit Total : 0.0280 UNITE(s)

Dupont Primer N° 7704S

N° de Lot: 1-28961-2

1-30270-4

42.0 AAC1101 N° 7775S, Dupont Activator - Reducer Chromabase

Commentair Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s)

N° 7775S, Dupont Activator - Reducer Chromabase

N° de Lot: 1-29932-3

1-29932-3

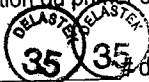
43.0 PRIMER Application primer



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation et l'application du primer selon I.G. 0008

Date: 5 juillet 11 Sceau:



de fiche de mélange:

N/A finition
N/A bâtisseur

44.0 INSPEC FINAL Inspection finale



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'inspection selon le dessin N° D2445.

Date: 06 JUL. 11 Sceau:



45.0 EMBALLAGE Emballage & Entreposage



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'emballage des pièces selon IG 0057

Date: 07 juillet 11 Sceau:



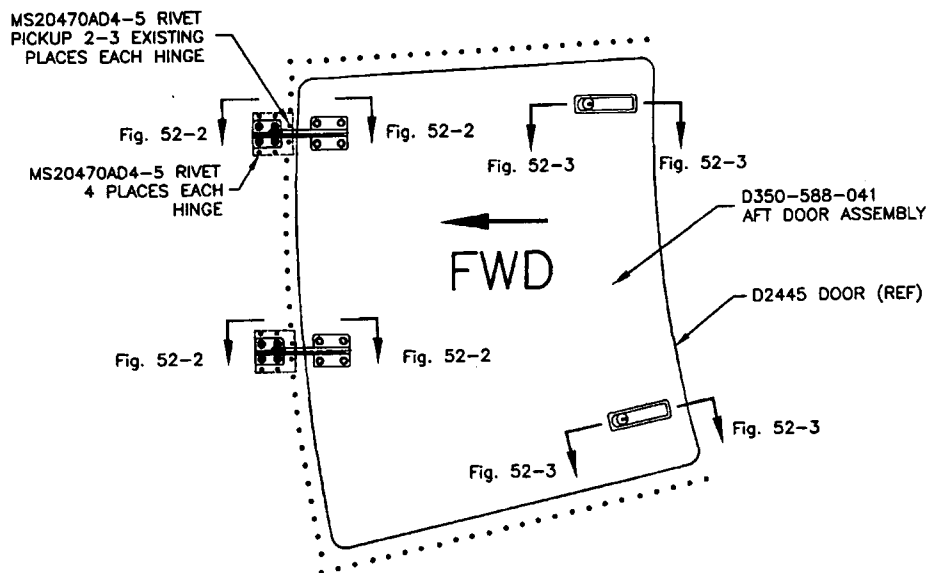


Figure 52-1: Baggage Door Outside View

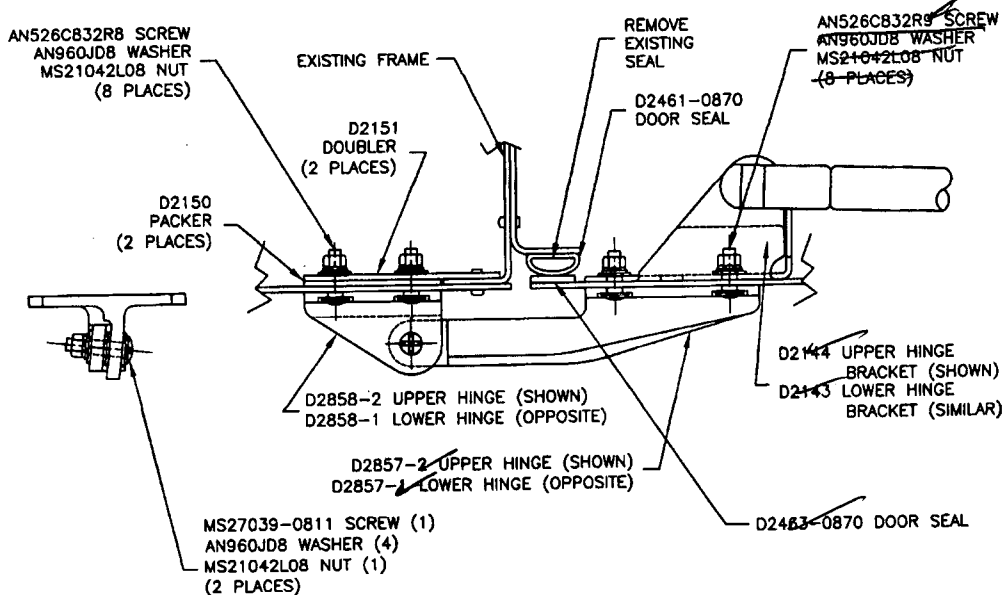


Figure 52-2: Hinge Detail

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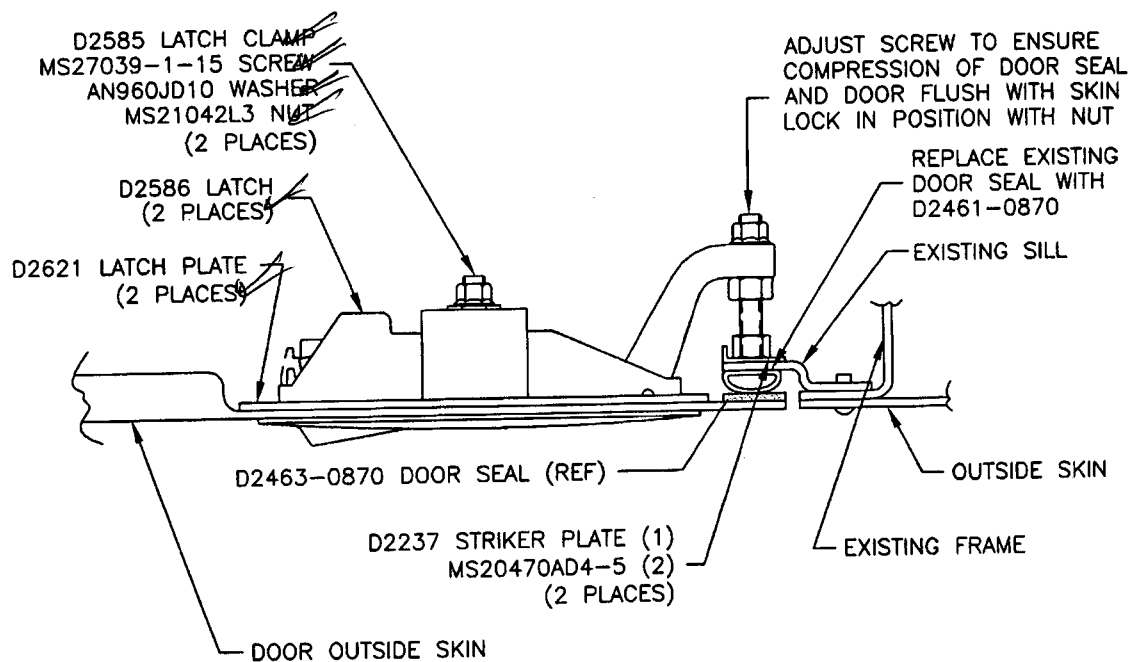


Figure 52-3: Latch Section

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52.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-588-011	1.0 lb	-21.0 in	-21.0 in-lb	+170.0 in	+170.0 in-lb
Aft Door Fwd Hinge Modification Kit	0.45 Kg	-0.53 m	-0.24 m-Kg	+4.32 m	+1.96 m-Kg
D350-588-041*	2.0 lb	-21.0 in	-42.0 in-lb	+170.0 in	+340.0 in-lb
Aft Door Assembly	0.91 Kg	-0.53 m	-0.48 m-Kg	+4.32 m	+3.93 m-Kg

* D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

52.4 PARTS LISTS

588 -041	588 -011	Part Number	Description
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
1	1	D2143	HINGE DOUBLER
1	1	D2144	HINGE DOUBLER
2	2	D2150	HINGE PACKER
2	2	D2151	HINGE DOUBLER
1	1	D2153-3315-10	GAS SPRING ASSY.
1	1	D2154	STUD BRACKET
2	2	D2237	STRIKER PLATE
1	1	D2445	DOOR
1	1	D2461-0870	NEOPRENE D SEAL
1	1	D2463-0870	1/2" FOAM SEAL
	2	D2583	LATCH BRACKET
2	2	D2585	LATCH CLAMP
2	2	D2586	LATCH
	1	D2587	PLUG
1	1	D2589	KEYS, KEY CHAIN
2	2	D2621	LATCH PLATE
1	1	D2690-17	CABLE, DOOR STOP
1	1	D2857-1	LOWER HINGE BRACKET
1	1	D2857-2	UPPER HINGE BRACKET
1	1	D2858-1	LOWER HINGE BRACKET
1	1	D2858-2	UPPER HINGE BRACKET
8	8	AN526C832R8	SCREW (or AN526-832R8)
8	8	AN526C832R9	SCREW (or AN526-832R9)
2	2	AN526C1032R7	SCREW (or AN526-1032R7)
24	24	AN960JD8	WASHER (-8)
4	4	AN960JD10	WASHER -2
12	12	MS20426AD3-4	RIVET
18	18	MS20470AD4-5	RIVET
18	18	MS21042L08	NUT (or MS21042-08) -8
4	4	MS21042L3	NUT (or MS21042-3) -2
2	2	MS27039-1-15	SCREW
2	2	MS27039-0811	SCREW
1	1	N/A	1 SQUARE ft. OF 9 oz. GLASS CLOTH (S-CLASS)

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52-00-00

Eric Charbonneau

From: Eric Charbonneau <echarbonneau@dartaero.com>
Sent: July 27, 2011 9:11 AM
To: 'Paul Slusarczyk'
Cc: 'ckerr@dartaero.com'
Subject: RE: BOM D350-588-041 P/N AN960JD8

All "AN" (Army Navy) hardware is slowly being replaced by "NAS" (National Aerospace Standard) hardware as it's harder to find AN hardware now a days, in this case the NAS1149DN832J is equivalent to AN960JD8, that is why you are not seeing the AN washer in the list. QSI 017 has most of our acceptable alternates, I think Kim just finished updating it.

Eric

From: Paul Slusarczyk [mailto:pslusarczyk@dartaero.com]
Sent: July 26, 2011 2:40 PM
To: echarbonneau@dartaero.com
Cc: ckerr@dartaero.com
Subject: BOM D350-588-041 P/N AN960JD8

Hi Eric,

For the subject assembly the parts list on the installation instructions calls for qty 24 of the AN960JD8, on the BOM in Intuitive, this washer is not listed at all. However, on assembly D350-588-011, both the installation instruction parts list and BOM in Intuitive match. Can you look into this and advise which is correct. Ref NCR 11-447.

Thanks

Paul